



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4776-1
Job Sheet 168412



Part No: D4776-1

Job Qty: 40 ea

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/14/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV D SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Machining		P.P. 17/11/30
100	Doosan	40 pcs	11/23/17	11/23/17	0.54	21.28	Doosan		P.P. 17/11/30
105	QC	40 pcs	11/23/17	11/23/17	0.00	0.00	QC2		P.P. 17/11/30
111	QC	40 pcs	11/23/17	11/23/17	0.00	0.00	QC8		marc 17/11/30
112	HandFinish	40 pcs	11/23/17	11/23/17	0.00	1.15	HandFinish1		2017-12-04 BSC
113	QC	40 pcs	11/23/17	11/23/17	0.00	0.00	QC7		BEB 2017/12/06
115	Powdercoat	40 pcs	11/24/17	11/24/17	0.00	0.46	Powdercoat1		DKM 17-10
116	QC	40 pcs	11/24/17	11/24/17	0.00	0.00	QC3		38
130	Packaging	40 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3	ST/11/30	9-89
140	QC21-SA	40 Ea	11/24/17	11/24/17	0.00	0.00	QC21		9-89

Part Op 100 - 1- Turn as per Folio FB167 Dwg D4776 Rev: 2

Descriptions: 115 - MASK .403 ROUND SECTION AS PER DWG

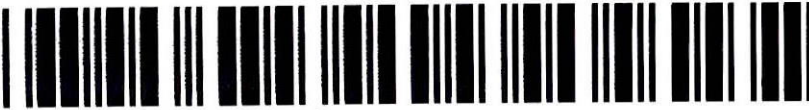
DEC 07 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6R1.500	12	13	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis .880	0.880Inches ± 0.030	0.910 0.850		
2	Basket Strut Clevis .440	0.438Inches ± 0.010	0.448 0.428		
3	Basket Strut Clevis .382	0.380Inches ± 0.030	0.410 0.350		
4	Basket Strut Clevis .625	0.625Inches ± 0.010	0.635 0.615		
5	Basket Strut Clevis 1.750	1.750Inches ± 0.030	1.780 1.720		
6	Basket Strut Clevis 3.500	3.500Inches ± 0.030	3.530 3.470		
7	Basket Strut Clevis 45°	45.000Degrees ± 0.500	45.500 44.500	Angle	



Basket Strut Clevis

PART NO: D4776-1
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 11/30/17
Job No: 168412

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Thermoforming Large Fab ☐ Cross tube Small Fab ☐ Finishing Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality Other ☐	
Disposition		QTY Effective :		MRB (QS1042) Approval	
Completed By		Lead hand / Supervisor Approval Verification		QC / QA Coordinator Approval	
FAULT CATEGORY					
Temperature/Cure	Set-up	BOM/Route	Broken/Damage/Defect	Inspection Incomplete/Unqualified	Contamination
centric	ple/Wave	Tube	Drill Holes	Instructions Incomplete/Unclear	Power Loss/Surge
					Folio/Program
					Grain
					Wrong Stock Pulled
					Out of Sequence
					Off-set
					Mislabeled
					Fit/Function
					Misaligned/off center
					Positioned Wrong
					Outside Dimensions
					Over/Under tolerance
					Part Incorrect
					Part Lost/Missing
					Part Moved
					Drawing
					Finish
					Misread
					Turning Sequence

8	Basket Strut Clevis		0.030Inches ± 0.030	0.060 0.000	
9	Basket Strut Clevis	0.060	0.060Inches ± 0.030	0.090 0.030	Radius
10	Basket Strut Clevis	0.198	0.196Inches + 0.006 - 0.001	0.202 0.195	Diameter
11	Basket Strut Clevis	0.262	0.261Inches + 0.006 - 0.001	0.267 0.260	Diameter
12	Basket Strut Clevis	0.410	0.410Inches ± 0.030	0.440 0.380	Radius
13	Basket Strut Clevis	1.130	1.130Inches ± 0.030	1.160 1.100	
14	Basket Strut Clevis	0.188	0.188Inches ± 0.010	0.198 0.178	
15	Basket Strut Clevis	0.189	0.190Inches ± 0.030	0.220 0.160	
16	Basket Strut Clevis	0.500	0.500Inches ± 0.030	0.530 0.470	
17	Basket Strut Clevis	0.750	0.750Inches ± 0.010	0.760 0.740	
18	Basket Strut Clevis	0.400	0.403Inches + 0.000 - 0.005	0.403 0.398	Diameter
19	Basket Strut Clevis	0.130	0.130Inches ± 0.030	0.160 0.100	Radius
20	Basket Strut Clevis	0.753	0.750Inches + 0.010 - 0.000	0.760 0.750	
21	Basket Strut Clevis	0.150	0.160Inches ± 0.030	0.190 0.130	
22	Basket Strut Clevis	45°	45.000Degrees ± 0.500	45.500 44.500	Angle

Plex 11/14/17 1:39 PM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					